

Date: Monday, 6/19/2006 11:30:55 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
Job Number : 27648
Estimate Number : 10282
P.O. Number : N/A
This Issue : 6/19/2006 **S.O. No.** : N/A
Prsht Rev. : NC
First Issue : N/A **Type** : SMALL /MED FAB
Previous Run : 27407
Written By :
Checked & Approved By :
Comment : Est:F 02.04.16 Added dwg Rev.C1 NG

Drawing Name : STRUT
Part Number : D2565107
Drawing Number : D2565 REV E
Project Number : N/A
Drawing Revision : E
Material : N/A
Due Date : 7/10/2006 **Qty:** 20 **Um:** Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M304TR0750W049	304 RD Tube .750 x .049W
		Comment: Qty.: 1.1751 f(s)/Unit Total : 23.5011 f(s) Material: 304/316 SS tubing 0.750" Dia. x 0.049" wall (M304TR0750W049) Batch No: M101593(α16) / M100599(α4) FF 06.08.08 20
2.0	BRAKE NC	NC BRAKE
		Comment: BRAKE NC Punch as per Dwg D2565 using DT 8313 FF 06.08.08 20
3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
		Comment: SMALL & MEDIUM FAB RESOURCE 1 Deburr M100/08/09 Press MF 06/09/06 20
4.0	QC5	INSPECT WORK TO CURRENT STEP
		Comment: INSPECT WORK TO CURRENT STEP SR 06/09/06 20
5.0	POWDER COATING	POWDER COATING
		Comment: POWDER COATING Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3 FC 06 09 11 20
6.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
		Comment: INSPECT POWDER COAT P16/9/12 20

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 04/09/12

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Monday, 6/19/2006 11:30:56 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STRUT

Job Number: 27648

Part Number: D2565107

Job Number:



Seq. #: Machine Or Operation:

Description :

7.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST/85

AB 06/09/12

(20)

8.0 DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

(20)
DP 06/09/12

Job Completion



U 06-09-12

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

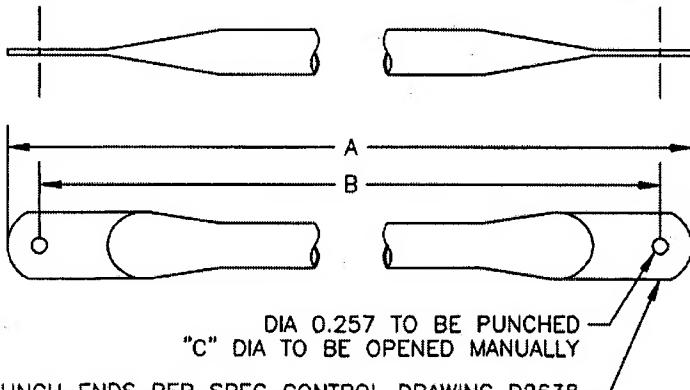
NOTE: Date & initial all entries QA: N/C Closed: _____ Date: _____



DESIGN 	DRAWN BY 	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. D2565	REV. E SHEET 1 OF 1
DATE 04.05.05	TITLE STRUT		SCALE 1:3

RELEASED
04 05 05 - #

A	96.05.03	NEW ISSUE
B	97.03.15	CORRECT D2565-111 DIM. A
C	98.10.05	UPDATED MATERIAL NOTE (TSR A603)
D	02.06.05	ADD -3XX PARTS; ADD FINISH
E	04.05.05	ADD D2565-401-411; RMV ANGLE D



PUNCH ENDS PER SPEC CONTROL DRAWING D2638

PART #	A	B	DIA C
D2565-101	20.52	19.72	0.316
D2565-103	18.21	17.41	0.316
D2565-105	20.19	19.39	0.316
D2565-107	13.43	12.63	-
D2565-109	12.31	11.51	-
D2565-111	13.65	12.85	-
D2565-201	22.79	22.00	0.316
D2565-203	20.75	19.95	0.316
D2565-205	21.22	20.42	0.316
D2565-207	16.07	15.27	-
D2565-209	15.16	14.36	-
D2565-211	14.14	13.34	-
D2565-301	27.03	26.23	0.316
D2565-303	25.34	24.54	0.316
D2565-305	23.73	22.93	0.316
D2565-307	20.86	20.06	-
D2565-309	20.17	19.37	-
D2565-311	16.30	15.50	-
D2565-401	18.29	17.49	0.316
D2565-403	15.64	14.84	0.316
D2565-405	19.45	18.65	0.316
D2565-407	10.79	9.99	-
D2565-409	9.34	8.54	-
D2565-411	13.81	13.01	-

GENERAL NOTES

- 1) MATERIAL: AISI 304/316/318 SS 0.750 OD X 0.049 WALL
(REF DART SPEC. M304TR0.750W0.049)
ENSURE SEAMLESS TUBE IS USED
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005
- 3) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

SHOP COPY
RETURN TO
ENGINEERING
CONTROLLED COPY.
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 27648